

Work Order ID 53436

November 4, 2009 10:38:54 AM



Page 1

Item ID:	D3836-042	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Rib Assembly (Basket Lid, RH)					
Start Date:	11/04/09	Start Qty:	2.00		Cust Item ID:	
Required Date:	11/06/09	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	Tooling:	Date:	Run	Start	
	QC:		Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3836	Rev A								

100 Large Fab 0.00 *09.11.04* * Custom made for DSI 9473 conversion

Large Fab Memo 0.00
1- cut D3836-2 and D3836-3 rib as per dwg D3836-2- remove identification markings 3- deburr

PD 09.11.04

110 QC5- Inspect part completeness to step on W/O 0.00

QC Memo 0.00
Quality Control

⇒ Soluloy

Ⓢ

120 Large Fab 0.00

Large Fab Memo 0.00
1- weld D3836-2 to D3836-3 and drill hole (3/16") using DT9447 jig and open to finish size as per dwg D3836-1- weld D3327-3 spacer bushing as per dwg D3836-1 A/R ER316 S.S. Rod Batch: *HA* 3- grind weld flush where indicated on dwg D

M109213

PD 09.11.04

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Item ID: D3836-042

Accept



Setup Start



Revision ID: A

Stop



Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 11/04/09 Start Qty: 2.00



Cust Item ID:

Required Date: 11/06/09 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC Memo 0.00

Quality Control

Cpl 09 11 04

140 QC5- Inspect part completeness to step on W/O 0.00



QC Memo 0.00

Quality Control

=> 507/11/04

(2)

150 Identify as per dwg & Stock Location: Basket 0.00



Packaging Memo 0.00

Packaging

D 09.11.04

to be used only on w/o

5/11/04

53397 + 53407

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Page 3

Item ID: D3836-042

Accept



Setup Start



Revision ID: A

Stop



Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 11/04/09 Start Qty: 2.00



Cust Item ID:

Required Date: 11/06/09 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/05

BL0911-5

Picklist Print

November 4, 2009 10:38:53 AM

Page 1

Work Order ID: 53436

Parent Item: D3836-042RevA

Parent Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 11/04/09

Required Date: 11/06/09

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2327-3RevD		Manufactured	No			100	Each	40.0000	2.0000			
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Spacer Bushing

<u>Warehouse</u>	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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Main Warehouse

ST	40	
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44274	21	
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44365	9	
-------	---	--

51126	10	
-------	----	--

N/A E
09.11.04

M304TS0.750W.065

Purchased

No

100

f

100.7468 3.7491



304 SQ Tube .75x.75x.065W

<u>Warehouse</u>	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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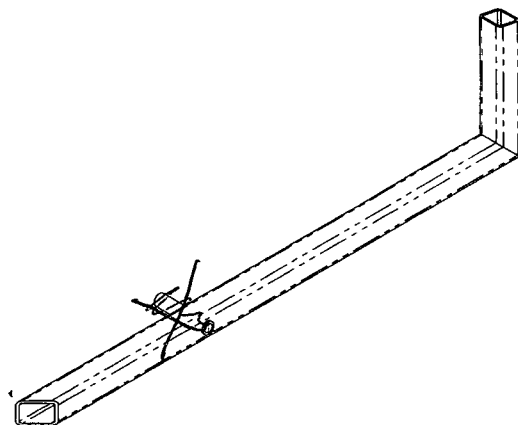
Main Warehouse

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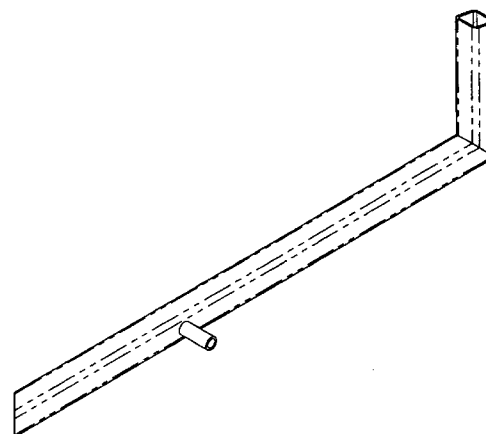
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3.7491 JY 09/11/05

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3836-041	RIB ASSY (BASKET LID, LH)
2		X	D3836-042	RIB ASSY (BASKET LID, RH)
3	1	1	D2327-3	SPACER BUSHING
4	1		D3836-1	RIB
5		1	D3836-2	RIB
6	1	1	D3836-3	RIB



D3836-042 RIB ASSY (BASKET LID, RH)



D3836-041 RIB ASSY (BASKET LID, LH)

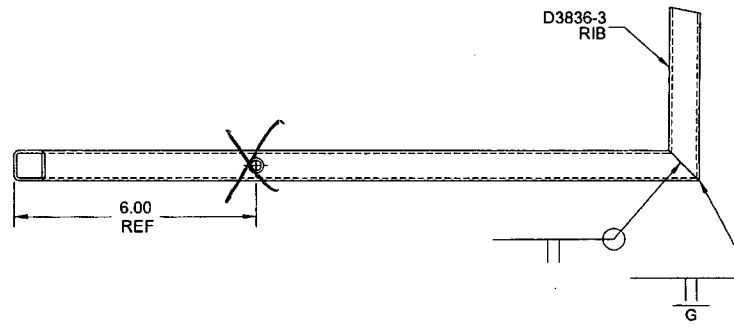
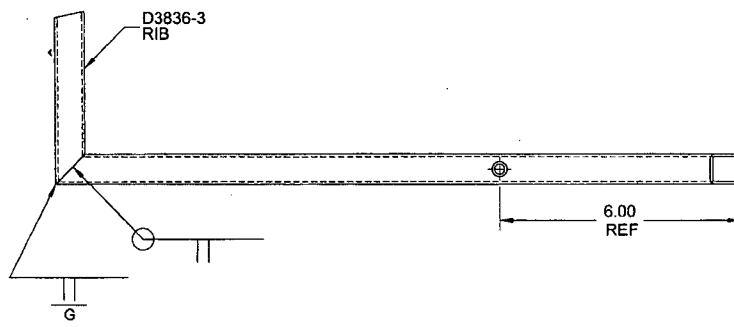
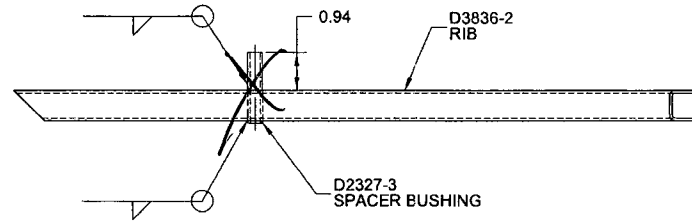
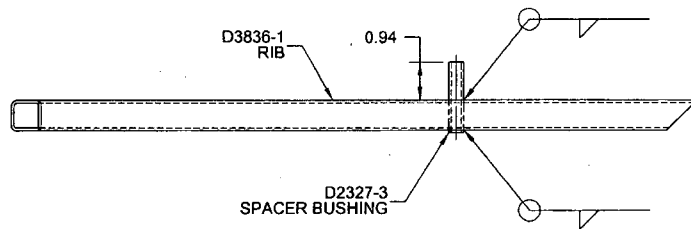
*W/O
5343*

RELEASED
08/11/24 RMP

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.99 lbs EACH
 8) WELD PER DART QSI 004

A		NEW ISSUE		MB	08.09.24
REV.		DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN					
CHECKED	<i>R/S</i>	DRAWING NO.		SHEET 1 OF 3	
MFG. APPR.	<i>[Signature]</i>	D3836			
APPROVED	<i>[Signature]</i>	TITLE		SCALE	
DE APPR.	<i>[Signature]</i>	RIB ASSY (BASKET LID)		NTS	
DATE	08.09.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>			

Mo 5343 u



D3836-041 RIB ASSY (BASKET LID, LH)

D3836-042 RIB ASSY (BASKET LID, RH)

RELEASED
08/11/18 JHT

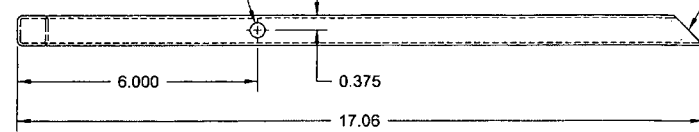
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3836	REV. A
MFG. APPR.			SHEET 2 OF 3
APPROVED		TITLE RIB ASSY (BASKET LID)	SCALE
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40 53435

0.75 X 45°
CHAMFER

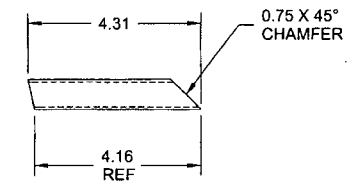


$\varnothing 0.375^{+0.020}_{-0.000}$ THRU



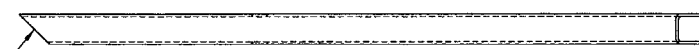
0.75 X 45°
CHAMFER

D3836-1 RIB

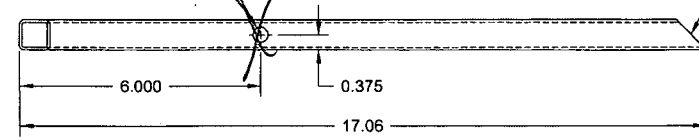


D3836-3 RIB

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CHAMFER

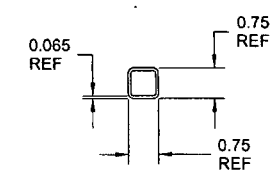


$\varnothing 0.375^{+0.020}_{-0.000}$ THRU



0.75 X 45°
CHAMFER

D3836-2 RIB



**TYPICAL SECTION
VIEW**

RELEASED
08/11/84

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D3836-1-2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.		D3836	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
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